

Atty's 21543

Pat. App. 09/603,528

CLAIM AMENDMENT

1           1. (currently amended) A method of making a sample tube  
2 ~~especially to receive a biological sample~~, comprising the steps of:  
3            injection molding an intermediate tube in one piece with  
4            a cylindrical wall and ~~an~~ a conical intermediate bottom spaced  
5            between ends thereof, integral with said wall and having an apex  
6           turned toward an end of said intermediate tube thereby forming a  
7           well adapted to receive a biological sample; and  
8            heating said an end of said intermediate tube and press-  
9           ing edges of said end inwardly toward an axis of said intermediate  
10          tube to thermally reform said tube and provide at least a partial  
11          bottom end for the sample tube; and  
12          rounding the bottom end of the sample tube outside an  
13          injection mold in which said tube is formed by pressing a heated  
14          stamp thereagainst to cause said bottom end of said sample tube to  
15          be shaped to a concavity of a concave recess of said stamp and to  
16          be only partially closed by said stamp whereby said bottom end is  
17          self-orienting upon insertion of the sample tube into a stand to  
18          permit removal of the biological sample from said well by a pi-  
19          pette.

2. - 4. (canceled)

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1               5. (currently amended) The method defined in claim 4 1  
2       wherein said stamp heats said intermediate tube to a temperature at  
3       least equal to the flow temperature of a thermoplastic synthetic  
4       resin constituting said intermediate tube.

6. - 9. (canceled)